

Work Order ID 112383

January-30-14 11:38:21 AM

112383

Page 1

Item ID: D4777-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rod End Bearing
 Start Date: 1/30/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 1/30/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 1-31-14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4777 | A |

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 22922
 Purchase Part Number: 59915K274 Supplier: Mc Master Carr
 Certificate of conformity is required

14/02/07 16

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure certificate of conformity is attached

14/2/10 (16)

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

DAS
 27
 3-89
14/2/10

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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January-30-14 11:38:21 AM

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Page 2

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Revision ID: Stop ***NS2***
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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|------------------|------------------|----------------|
| 130 | Identify as per dwg & Stock Location: <u>ST123</u> | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 16x | DAS 28 989 | 14-02-10 | |
| Packaging | | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14-02-13
14-02-11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Training | | | | | | | | | |
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|--|--|---|--|

Picklist Print

* January-30-14 11:38:20 AM

Page 1

Work Order ID: 112383

Parent Item: D4777-1

Start Date: 1/30/14

Required Date: 1/30/14

Parent Item Name: Rod End Bearing

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| 59915K274 Rod End Bearing | | Purchased | No | | | 110 | Each | 0.0000 | 1 | 16 | | 1/24/14 | (14) |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

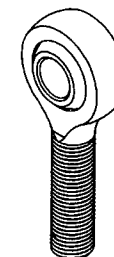
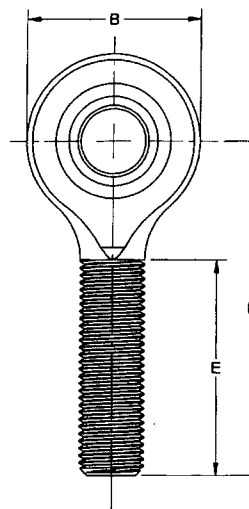
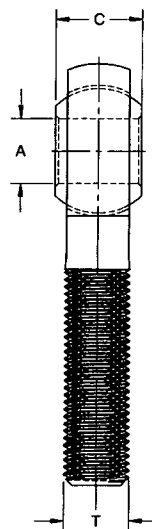
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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
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| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

SPECIFICATION CONTROL DRAWING



ROD END BEARING

112383 MCT
1401-31

| DART P/N | HOUSING MATERIAL | A | B | C | D | E | T (THREAD SIZE) | SUGGESTED SUPPLIER | SUGGESTED SUPPLIER P/N |
|----------|------------------|-------|------|-------|------|------|---------------------|--------------------|------------------------|
| D4777-1 | STAINLESS STEEL | Ø0.38 | 1.00 | 0.500 | 1.94 | 1.25 | 3/8-24 (RIGHT HAND) | MC MASTER CARR | 59915K274 |

RELEASED
2013-08-14

| | | | | |
|------------|-------------|-----|------|----------|
| A | NEW ISSUE | ... | AJS | 13.08.08 |
| REV. | DESCRIPTION | BY | DATE | |
| DESIGN | AJS | | | |
| DRAWN | AJS | | | |
| CHECKED | ... | | | |
| MFG. APPR. | ... | | | |
| APPROVED | ... | | | |
| DE APPR. | ... | | | |
| DATE | 13.08.08 | | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4777

REV. A
SHEET 1 OF 1

TITLE
ROD END BEARING

SCALE
NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22922

Purchase Order Date 2/7/2014

PO Print Date 2/7/2014

Page Number 1 of 2

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
6/14/2010

Contact Name

Vendor Phone 330 995 5500

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 10

Ship To Phone

Currency

USD

Ship Via:

FedEx PI collect

FOB

FCA - (Free Carrier)

Ship Acct:

| Line Nbr | Reference Vendor Part Number Line Comments Delivery Comments | Description/ Mfg ID | Req Date/ Taxable Promise Date | CD | Req Qty/ Unit of Measure | PO Unit Price | Extended Price |
|-------------|--|------------------------|--------------------------------------|----|--------------------------------|---------------|----------------|
| 1 | 92311A599 AS PER DWG D2712 REV. B B112534 | SET SCREW | 2/11/2014 Yes 2/11/2014 | | 100.00 Each | \$0.22 | \$21.60 |
| Line Total: | | | | | | | \$21.60 |
| 2 | 59915K274 AS PER DWG D4777 REV. A B112383 | Rod End Bearing | 2/11/2014 Yes 2/11/2014 | | 16.00 Each | \$17.14 | \$274.24 |
| Line Total: | | | | | | | \$274.24 |
| 3 | 93695K58 AS PER DWG D3802 REV. D B112283 | WINDOW SEAL | 2/11/2014 Yes 2/11/2014 | | 50.00 f | \$0.29 | \$14.72 |

PO Instructions: Procurement Quality Clauses
A005 right of entry
A013 self life controlled material
A026 certification of material conformance
A040 notification of quality escape

Note:



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO22922

Page 1 of 1

Order Placed By
Chantal Lavoie

02/07/2014

McMaster-Carr Number
7632245-01

| Line | Description | Ordered | Shipped |
|------|---|----------|---------|
| 1 | 92311A599 18-8 Stainless Steel Cup Point Set Screw, 5/16"-24 Thread, 5/8" Long, Packs of 50 | 2 Packs | 2 |
| | Unit Price: | \$10.80 | |
| | Extended Price: | \$21.60 | |
| 2 | 59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread | 16 Each | 16 |
| | Unit Price: | \$17.14 | |
| | Extended Price: | \$274.24 | |
| 3 | 93695K58 Oil-Resistant Neoprene/Vinyl/Buna-N Foam, Adhesive-Back, 1/4" Thick, 1" Width, 50' L, Black | 1 Each | 1 |
| | Unit Price: | \$14.72 | |
| | Extended Price: | \$14.72 | |

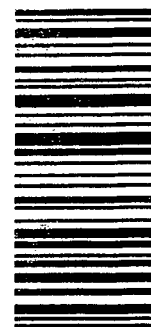
| LNS A82 | | | |
|--------------|---------|------|--------|
| 2 - 696 - 09 | 45 - 83 | A599 | 2 PK 1 |
| 3 - 481 | | | 2 |
| 1 - 256 | | | 3 |

Charges for this shipment

| | |
|---------------------|-----------------|
| Merchandise Amount: | \$310.56 |
| Total: | \$310.56 |

Dart Aerospace Ltd

EXP
INV



4 lbs
3 lines

Me
17x17x8

FW1WBP26
02/07/2014
12:09/12:57
530
Cycle 48

1141014300147

